

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010075**Date Inspected:** 24-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhou liu hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Trial assembly area

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 037907 perform FCAW welding on, base plate to Skin E from Inside south tower, lift 1 .The weld joint identified as SSD1- A111 B/H- 137. ZPMC CWI Identified as Mr. Zhau liu hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 070046 perform FCAW welding on, base plate to Skin E, outside South tower, lift 1 .The weld joint identified as SSD1- A111- B/H- 13. ZPMC CWI Identified as Mr. Zhou liu hai. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P5-F

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as south tower, Lift 3, 102.5 and 95.5 mtr. Fit lugs and diaphragm to Skin A, B and

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E. The weld designations reviewed are as follows:

SSTL3- 1 F/K – Jt. no. 108, 109, 116, 117, 124, 125, 98, 99, 104, 105, 134, 135, 126, 127–south, Lift 3-95.5mtr.

SSTL3-1 H/K –Jt. no. 33, 34, 47, 48, 99, 100, 105, 106, 57, 58, 49, 50 – 102.5 mtr.

Out side yard gratings and rails

PE-13,14, 15 – each 1 no. – Grating brackets

PE-3 – 3 nos – Grating bracket

SD1- A 734, A 735 – each 1 no. – Hand rails

SSD1-SA 231 – 1 no. – Hand rail

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
